# Work Order ID 55732

*January 29, 2010 8:25:08 AM*



**Item ID:** D3206-1 **Accept** **Setup** **Start**

**Revision ID:** **Stop**

**Item Name:** Pedal Arm

**Start Date:** 1/28/10 **Start Qty:** 10.00 **Cust Item ID:**

**Required Date:** 2/08/10 **Req'd Qty:** 10.00 **Customer:**

**Reference:**

**Run** **Start** **Stop**

**Approvals:** **Process Plan:** A **Date:** 10-1-29 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** / **Revision Nbr** | | | | | | | | | |
| D3206 / Rev A | | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| Waterjet | **Memo** | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3206 ☐Dwg Rev: A ☐Prog Rev: A ☐2- | | | | | | | | |
| 4130.125 | Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

IB 10-2-3

16

IB 10-2-3

=> Sidelot

XD

Pin →

Dart Aerospace Ltd

| W/O: 55732 | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/2/4 | # 120 | Took Qty +1 For QC inspection template | S | 10/02/04 | +1 | L | S 10/02/04 |
| | | | | | | | |

Part No: D3206-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

# Work Order ID 55732

*January 29, 2010 8:25:08 AM*



**Item ID:** D3206-1 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Pedal Arm

**Start Date:** 1/28/10 **Start Qty:** 10.00 **Cust Item ID:**

**Required Date:** 2/08/10 **Req'd Qty:** 10.00 **Customer:**

**Reference:**

**Run Start**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130<br>Powdercoat<br>Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3<br>M112588<br>**Memo**<br>START TIME: 1:00pm ☐OVEN TEMPERATURE:<br>1:30pm ☐FINISH TIME: 320°F | 0.00<br>0.00 | | | | 15 | 0 | | |
| 140<br>QC<br>Quality Control | QC3- Inspect Part Finish<br>**Memo** | 0.00<br>0.00 | | | | 15 | | | |
| 150<br>Packaging<br>Packaging | Identify as per dwg & Stock Location: 197<br>**Memo** | 0.00<br>0.00 | | | | 15 | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

# Work Order ID 55732

*January 29, 2010 8:25:08 AM*



**Item ID:** D3206-1 **Accept** **Setup** **Start**

**Revision ID:** **Stop**

**Item Name:** Pedal Arm

**Start Date:** 1/28/10 **Start Qty:** 10.00 **Cust Item ID:**

**Required Date:** 2/08/10 **Req'd Qty:** 10.00 **Customer:**

**Reference:**

**Run** **Start**

**Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:**

**Stop**

**QC:** **Date:** **SPC (Y/N):** **Date:**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 10/02/11 |
| QC<br>Quality Control | **Memo** | 0.00 | | | | | | | |

10.02.11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

# Picklist Print

*January 29, 2010 8:25:12 AM*



1

**Work Order ID:** 55732

**Parent Item:** D3206-1

**Parent Item Name:** Pedal Arm

**Start Date:** 1/28/10 **Required Date:** 2/08/10

**Comments:** IPP A□04.04.15□New issue□KJ/RF□
IPP Rev:B Now On Waterjet 06-12-13 JLM

**Start Qty:** 10.00 **Required Qty:** 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M4130NS.125<br>4130 Sheet .125 (11GA) | | Purchased | No | | | 100 | sf | 37.5000 | 1.8526 3. | | R10-2-3 | |

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| MAT | 37.5 | |
| 103505 | 37.5 | 103505 |

16

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

| DART AEROSPACE LTD | Work Order: | 55732 |
|---|---|---|
| | | |
| **Description:** Pedal Arm | Part Number: | D3206-1 |
| | | |
| **Inspection Dwg:** D3206 **Rev:** A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø0.191 | +0.005/-0.001 | .192 | X | | | |
| Ø0.257 | +0.006/-0.001 | .258 | X | | | |
| 0.600 | +/-0.010 | .607 | X | | | |
| 5.350 | +/-0.010 | 5.350 | X | | | |
| 3.350 | +/-0.010 | 3.351 | X | | | |
| 1.400 | +/-0.010 | 1.405 | X | | | |
| 0.610 | +/-0.010 | .618 | X | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | JB | Audited by: | S | Prototype Approval: | N/A |
|---|---|---|---|---|---|
| Date: | 10-2-3 | Date: | 10/02/04 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 07.03.05 | New Issue | KJ/JLM | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

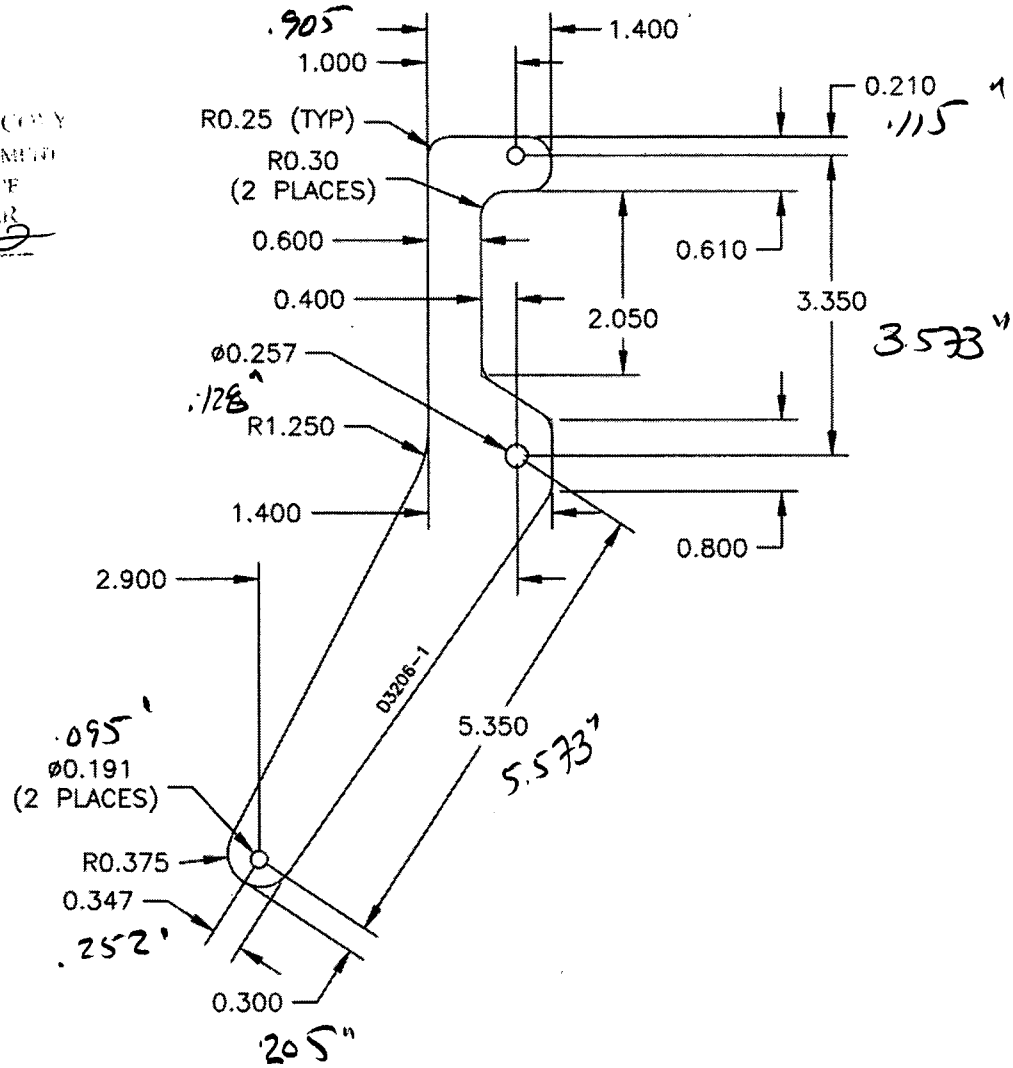
**NOTE:** Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| CHECKED | APPROVED | DRAWING NO.<br>D3206 | REV. A<br>SHEET 1 OF 1 |
| DATE<br>04.01.27 | | TITLE<br>PEDAL ARM | SCALE<br>1:2 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.04.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55732




NOTES:
1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
3) FINISH POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
4) ENGRAVE DART P/N AS SHOWN
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**Copyright © 2004 by DART AEROSPACE LTD**
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE